

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013846**Date Inspected:** 04-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed UT of approximately 10% of the repaired area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as OBG BK members (Inspection request # 005656). The weld designations reviewed are as follows:

1. BK001-025-06, 09, 02, 04
2. BK001-026-04~07, 09
3. BK001-027-02, 05, 06, 09
4. BK001-028-02, 04, 06, 09
5. BK001-029-02, 04, 06, 09

7DW+7EW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 019 located at DP642-001 counter weight side of segment. Welder is identified as Mr. Yun Chuansheng (045221). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-3213-B-U3b.

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8AW+8BW

Flaw Core Arc Welding (FCAW) welding was performed on weld joint 003 located at OBW8 deck plate splice on segment. Welder is identified as Mr. Cheng Hai Xia (045209). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-223(2)1T-2.

Flaw Core Arc Welding (FCAW) welding was performed on weld joint 003 located at OBW8 deck plate splice on segment. Welder is identified as Mrs. Cheng Hai Xia (045209). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-223(2)1T-2.

Flaw Core Arc Welding (FCAW) welding was performed on weld joint 004 located at OBW8 deck plate splice on segment. Welder is identified as Mr. Chen Dinghang (067138). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-223(2)1T-2.

7EW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA047 counter weight side of segment. Welder is identified as Mr. Chen Renzhi (058087). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR1222 R1 repair procedure.

Y Location of repairs areas by above noted welder (058087) is located at 5730mm.

8BE+8CE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 004 located at OBE8 cross beam side of segment. Welder is identified as Mr. Han Xiaofeng (058087). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and WR12791 R1 repair procedure.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Alaniz,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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